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D4785-041
Job Sheet 168158



Part No: D4785-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, LH/RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 12/27/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/25/17	0.00	0.00	Start Up Large Fab2		D.M.L. 18-1-10
100	Large Fab	1 pcs		12/26/17	0.00	25.00	Large Fab 1		18-01-13
110	QC	1 pcs		12/26/17	0.00	0.00	QC9		PD 18-01-17
120	QC	1 pcs		12/26/17	0.00	0.00	QC5		PD 18-01-17
125	HandFinish	1 pcs		12/26/17	0.00	0.52	HandFinish2		BE 18-01-18
130	Powdercoat	1 pcs		12/26/17	0.00	0.84	Powdercoat2		BR 18-01-18
140	QC	1 pcs		12/26/17	0.00	0.00	QC3		18-1-23
150	HandFinish	1 pcs		12/27/17	0.00	0.52	HandFinish4		18-1-21
160	QC	1 pcs		12/27/17	0.00	0.00	QC5		18-1-24
170	Packaging	1 pcs		12/27/17	0.00	0.00	Packaging3		18-1-21
180	QC21-SA	1 Ea		12/27/17	0.00	0.00	QC21		21

Part Op 100 - 1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs, weld as per dwg D4785 ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT***
Descriptions: OF BASE RIB ARE STRAIGHT*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends ***USE DT10158 WITH SHIM WHEN WELDING BOTTOM OF RIB D4785-115*** 3- weld hinge (3) and Mounting brackets as per dwg D4785
110 - ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding
120 - ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT***
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick kit and assemble

M 138467 START: 11:30 O.V.T: 375° FINISH: 11:45.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5005842	2	103	0	0
	D3913-1	1	12	0	0
	D3913-3 5018474	1	15	0	0
	D3913-9 5010881	1	6	0	0
	D3916-5 5026219	2	12	0	0
	D4016-1 5009181	3	1	0	0
	D4017-7 5012929	3	49	0	0
	D4020-11 5016763	2	18	0	0
	D4021-5 5021383	2	18	0	0
	D4034-041 5017545	1	6	0	0
	D4034-043 5017546	1	6	0	0
	D4785-1 5011912	2	2	0	0
	D4785-115 5014362	4	4	0	0
	D4785-117	2	2	0	0
	D4785-3 5006090	2x1	5	0	0

50301831x

150-HandFinish	D4785-5	5030179	3	9	0	0
	D4793-1	5007947	3	10	0	0
	D4793-3	5007972	1	7	0	0
	M304EX0.75-16F	2021100	33	515	0	0
	AN3-10A	5014736	6	244	0	0
	D2931	F86435-1	2	236	0	0
	D4672-1	5005866	2	51	0	0
	MS20600-AD4W3	5014431	2	277	0	0
	MS21042L3	5016501	6	1,328	0	0
	NAS1149DN832J		2	1,712	0	0
	NAS1149F0332P	5020603	12	2,740	0	0

Part Specifications

Specifications could not be found.

Plex 11/10/17 10:23 AM dart.poulin.mario

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Long Basket Base Assembly, LH/RH

PART NO: D4785-041

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 01/10/18

Job No: 168158